

Date: Wednesday, 1/30/2008 7:56:58 AM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37080 -2
Estimate Number : 11208
P.O. Number :
This Issue : 1/30/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Previous Run : 34198
Written By :
Checked & Approved By :
Comment : Est A 05.01.13 New issue KJ/JLM
est B 07.05.14 rev C dwg ec
est C 07.12.12 rev D dwg EC verified by:DD

Drawing Name : HANDLE
Part Number : D333015
Drawing Number : D3330 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 2/11/2008 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. # Machine Or Operation Description :

1.0 M1018R0375 1010-1025 Steel Bar



Comment: Qty.: 0.6999 f(s)/Unit Total : 13.9986 f(s)
1010-1025 Steel Bar

Material: AISI 1018-1025 0.375" Round Bar cut 8.00"long.

(M1018-R0.375)

Identify as D3330-15

Batch: M110346

M106996 → 1,5229

M110346 → 5,476

pl 09.02.04

X10

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



X10

Comment: LARGE FABRICATION RESOURCE 1
Fabricate handle as per Dwg D3330
Deburr

pl 09.02.04

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09-02-05 13

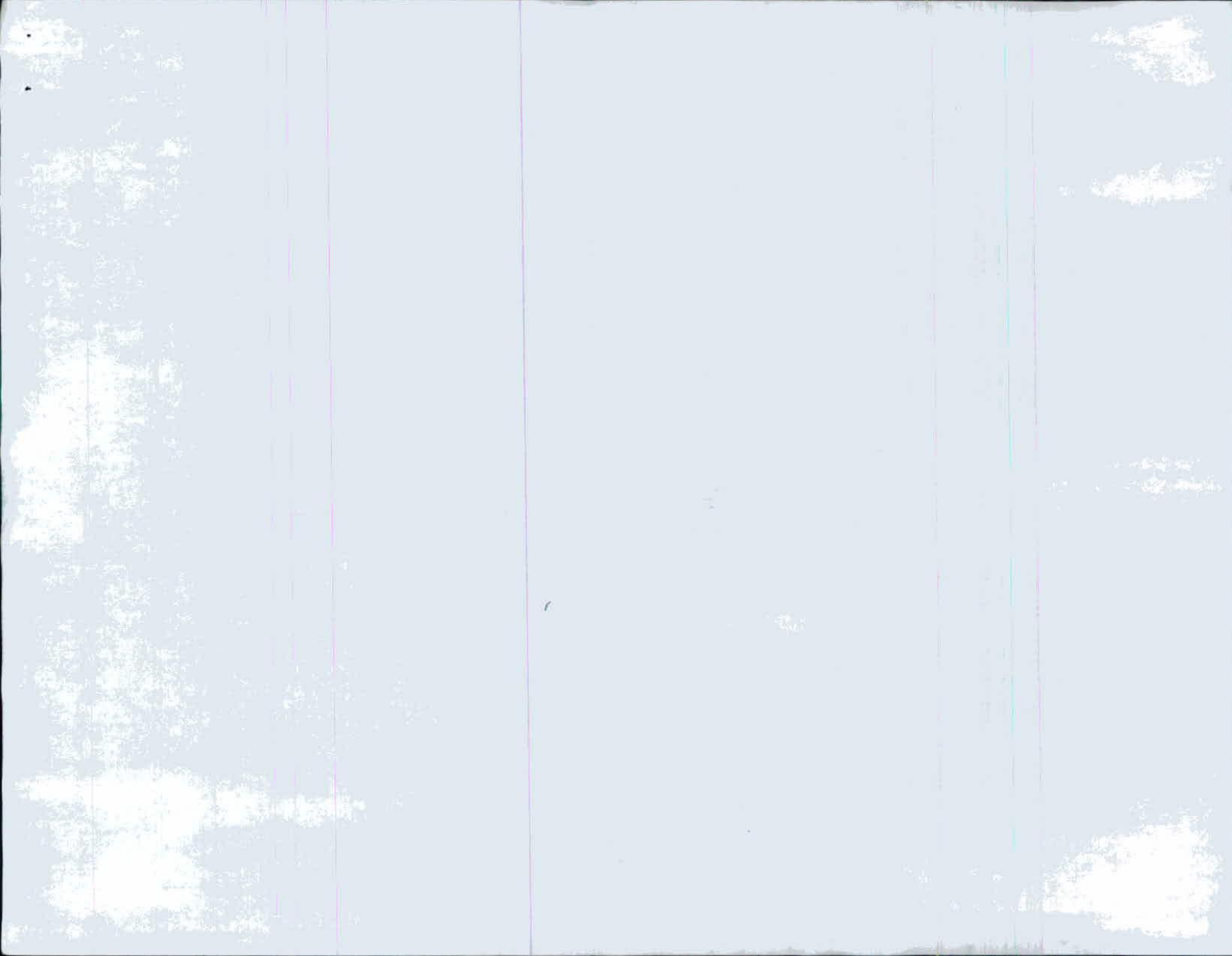
4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: MISC

pl 09.02.05

10



Date: Wednesday, 11/30/2006 1:00:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE

Job Number: 37080

Part Number: D333015

Job Number:



Seq. #:

Machine Or Operation:

Description:

50

QC21

FINAL INSPECTION/W/O RELEASE



09/02/05

Comment: FINAL INSPECTION/W/O RELEASE

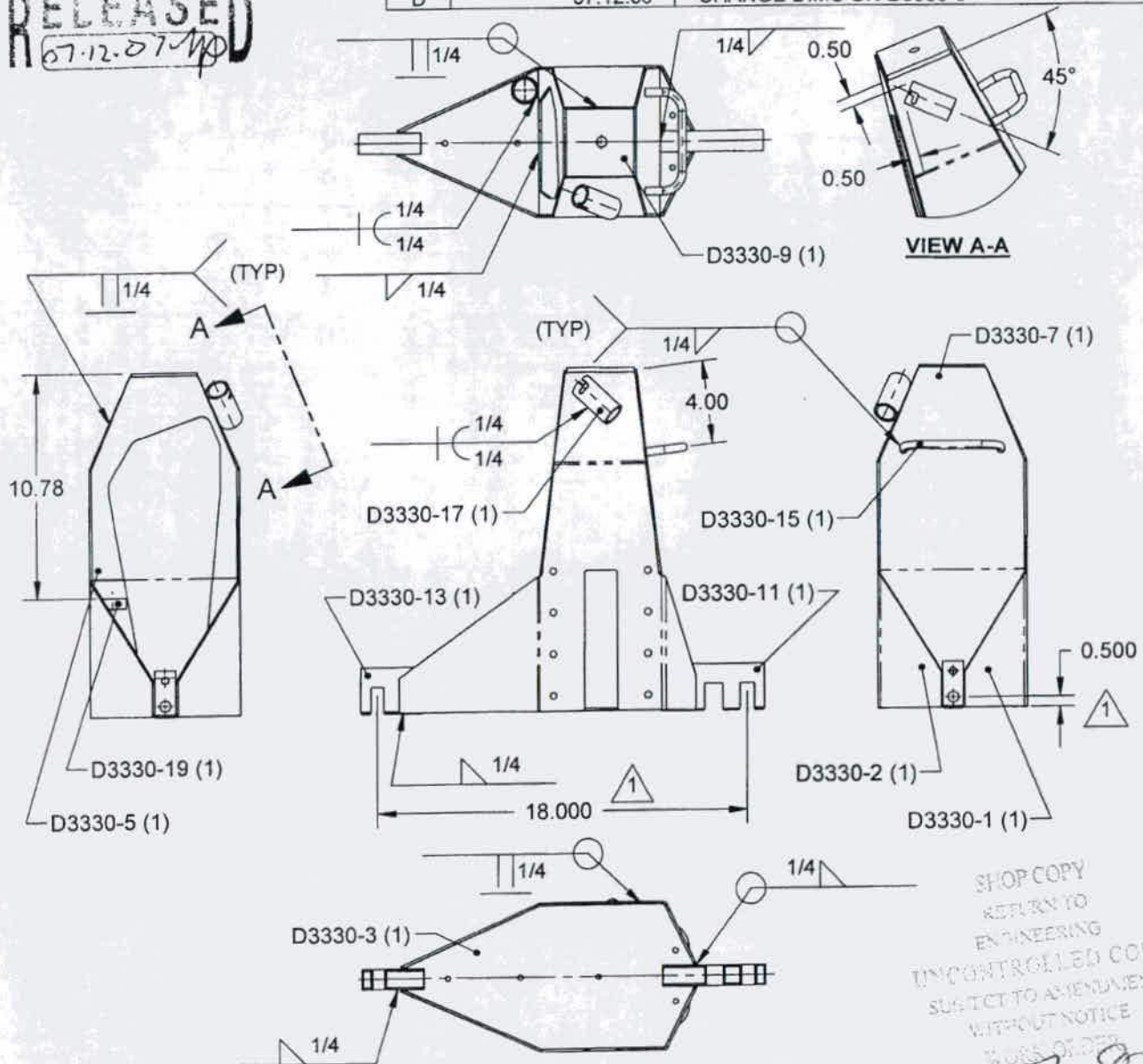
Job Completion



MF
09-02-05

DARTRELEASED
07-12-07

DESIGN B	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED S	APPROVED W	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

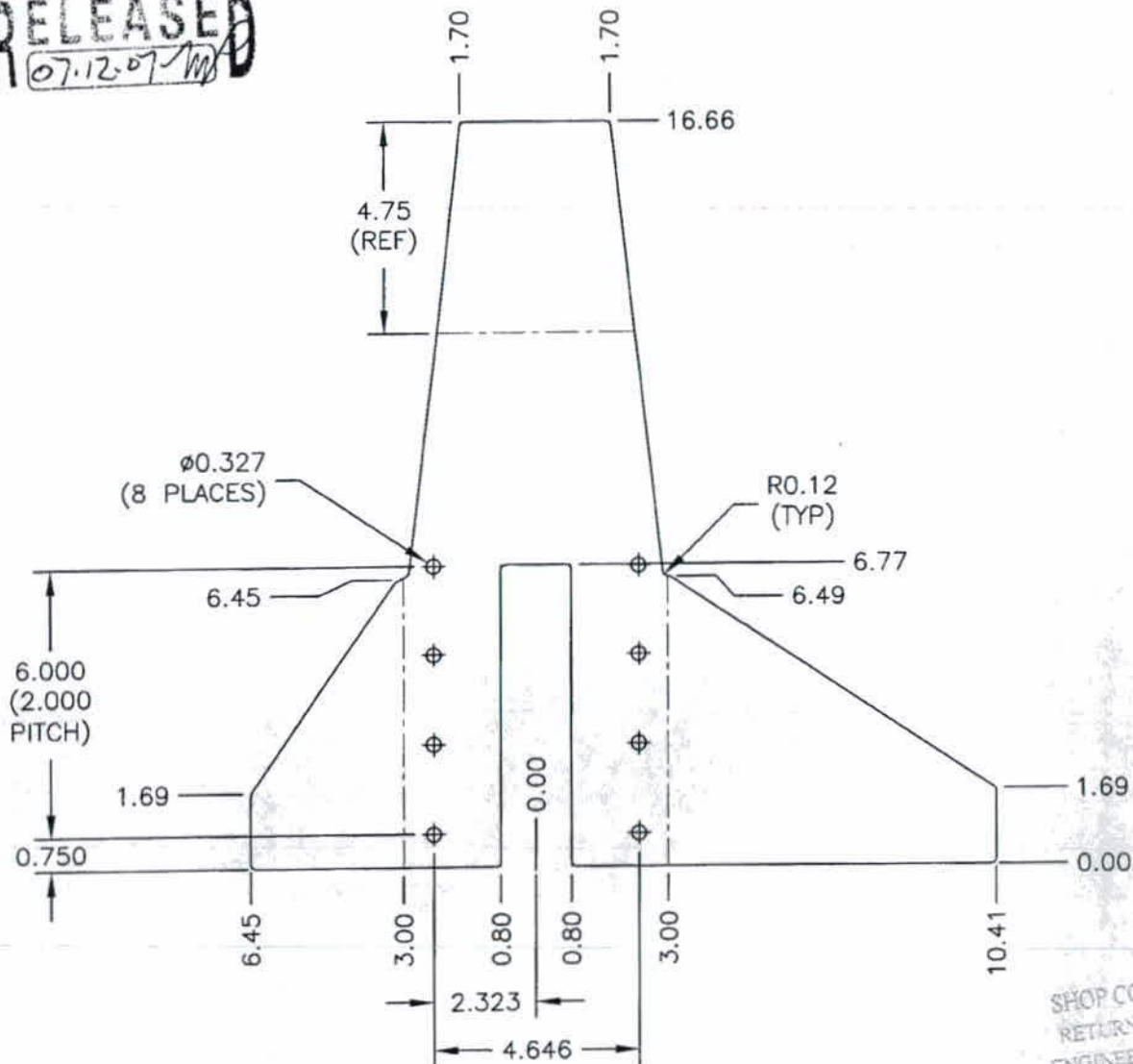
- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.12.07 *[Signature]***D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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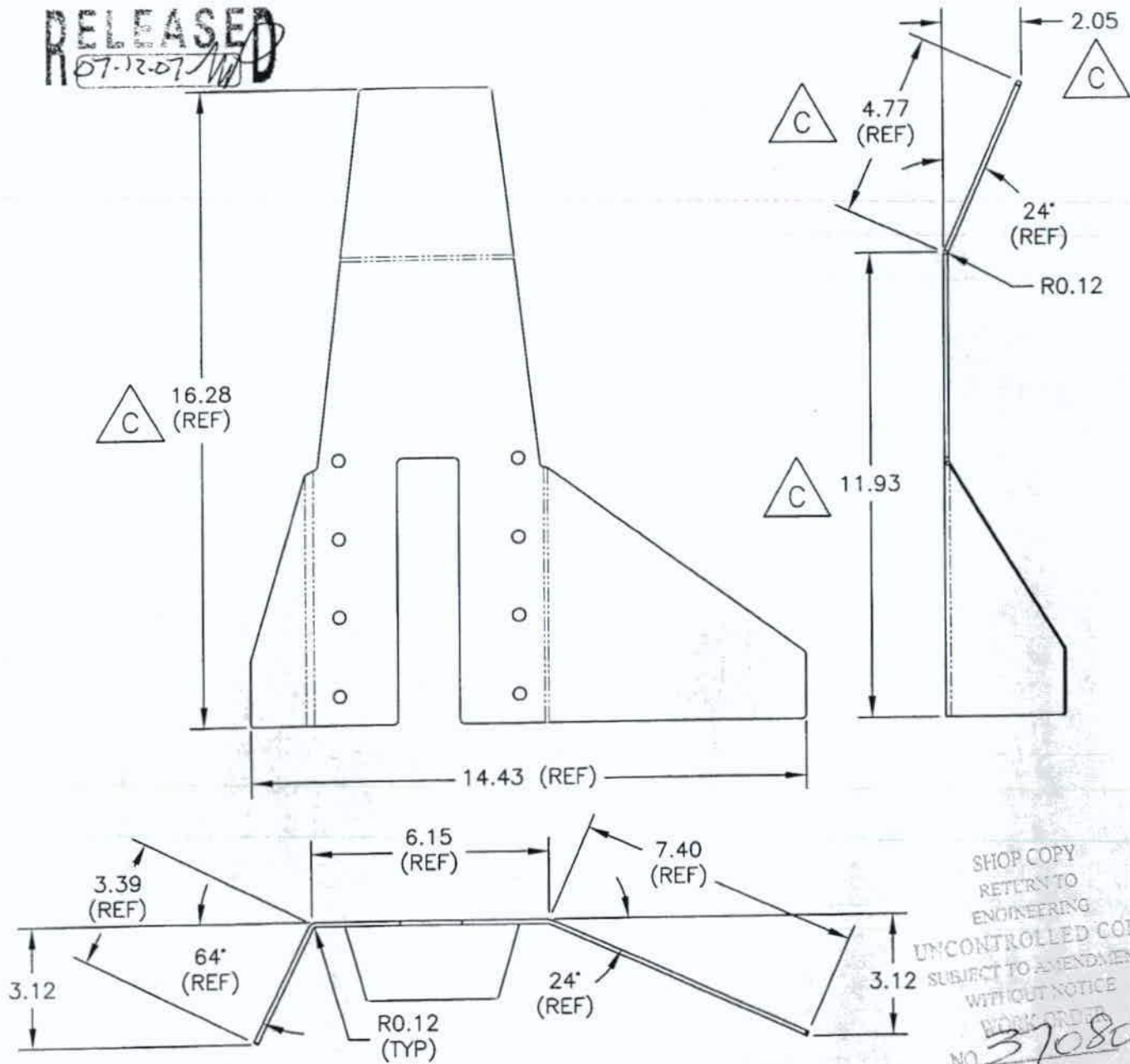
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

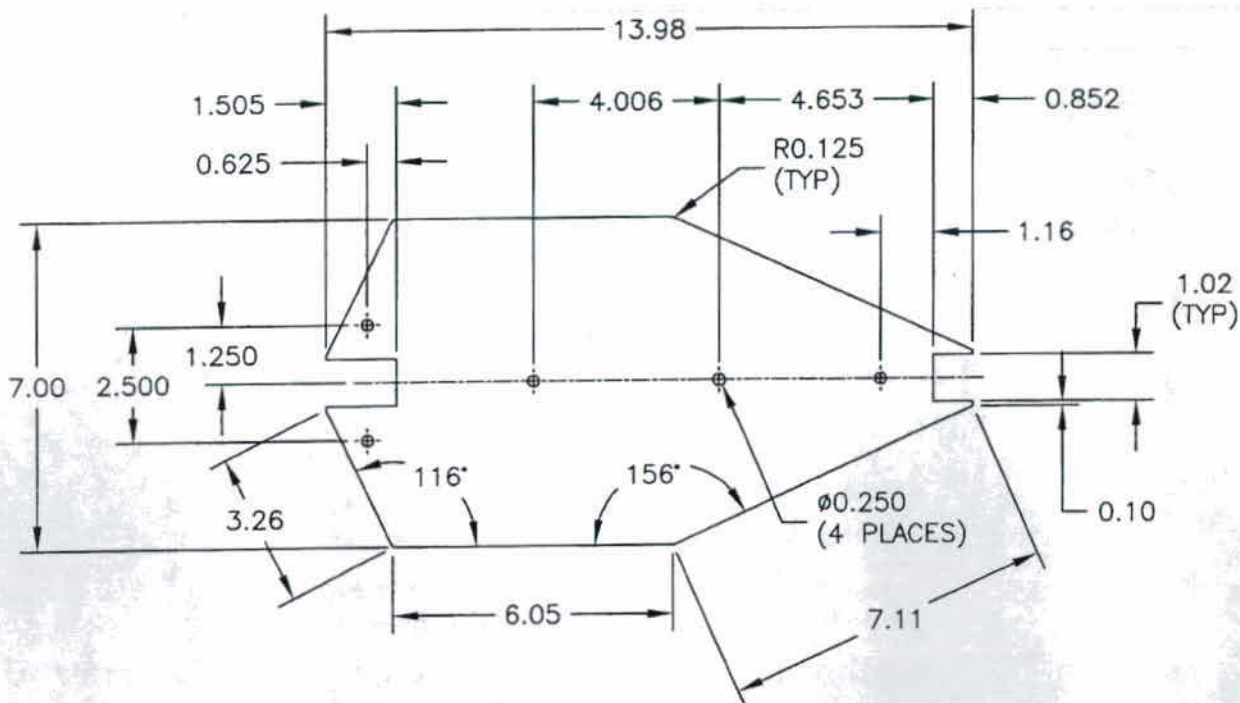
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D3330-3 PLATE

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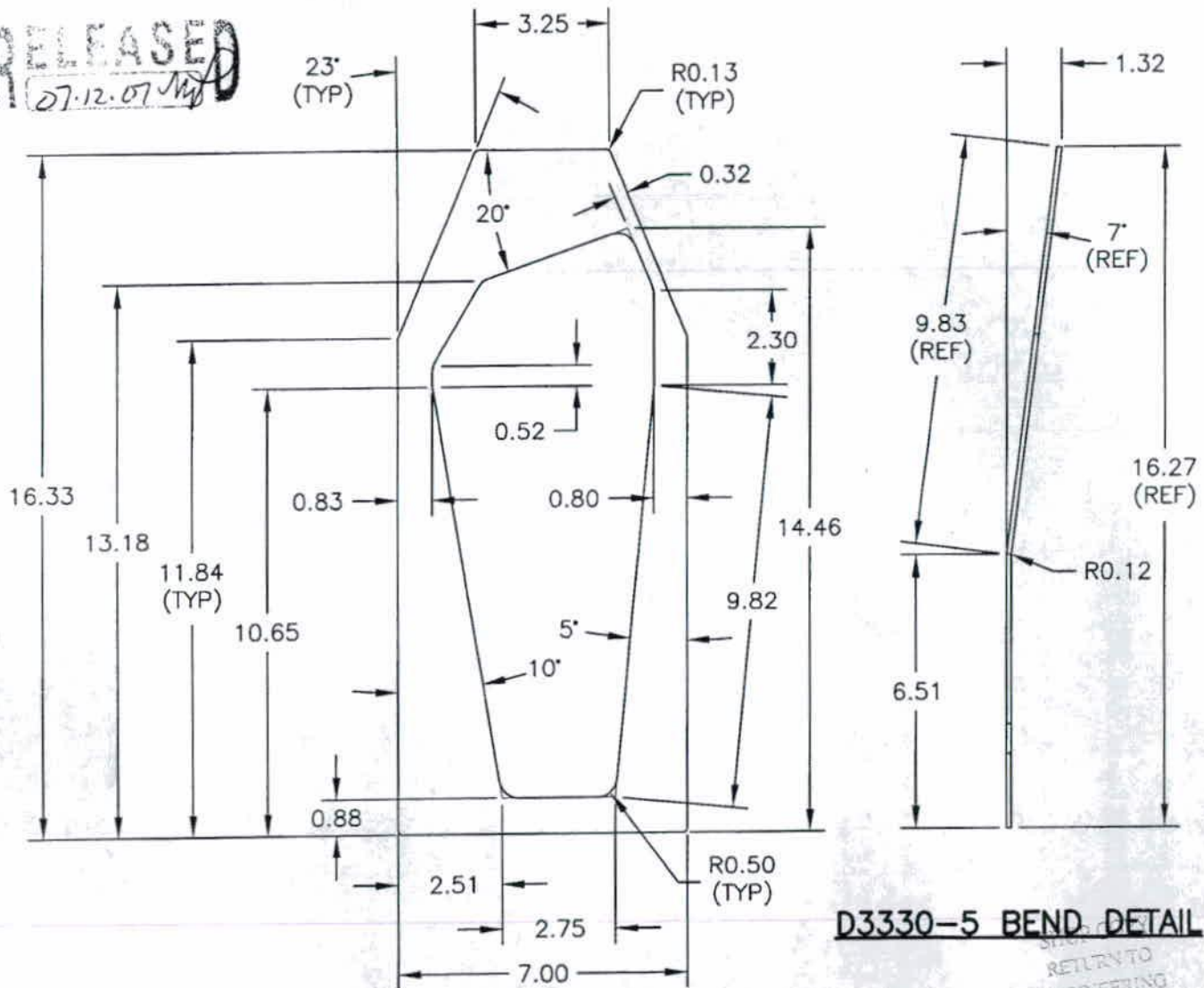
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:4

RELEASED
07.12.07**FLAT PATTERN****D3330-5 BEND DETAIL**RETURN TO
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NO. 37080**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

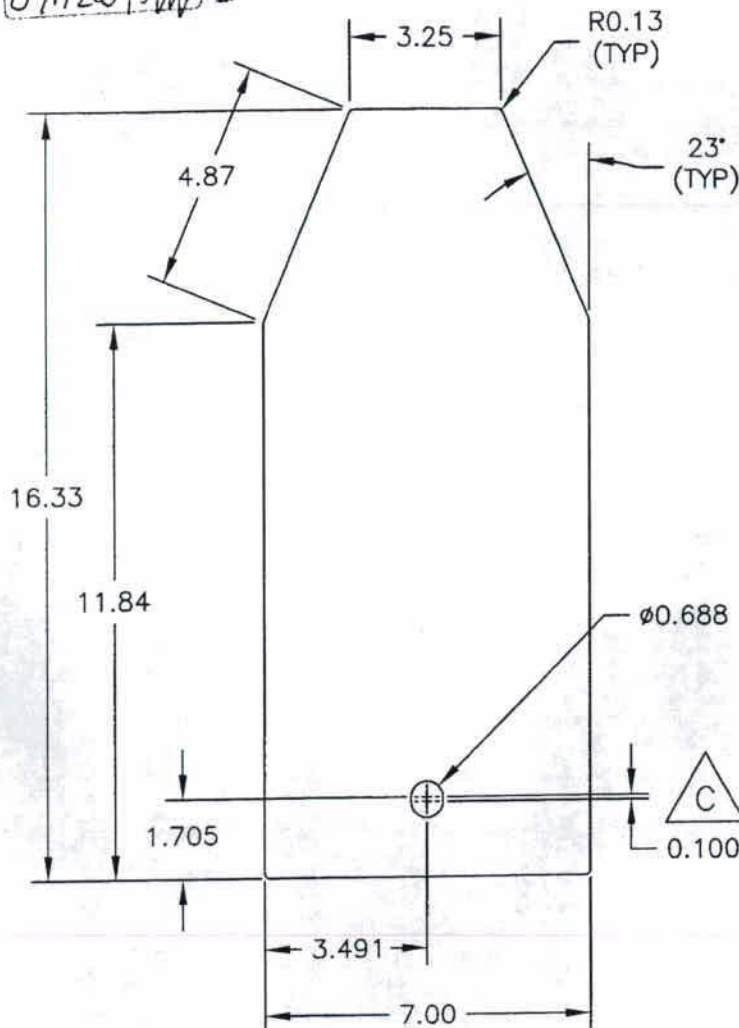
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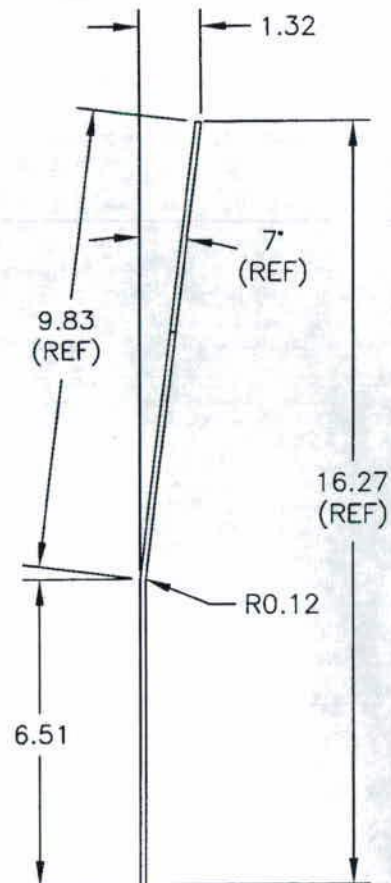
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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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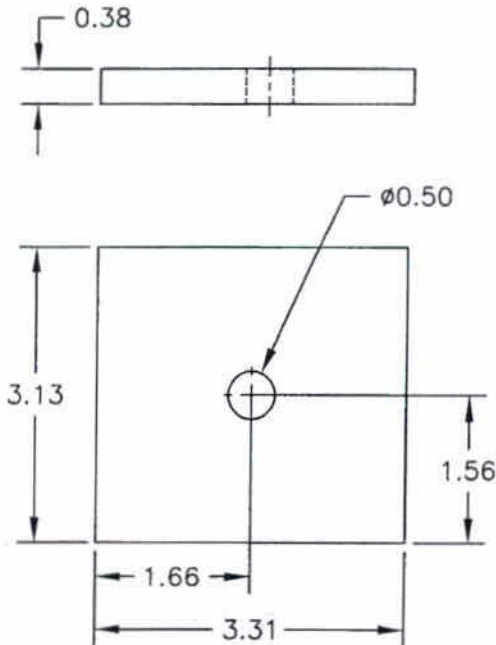
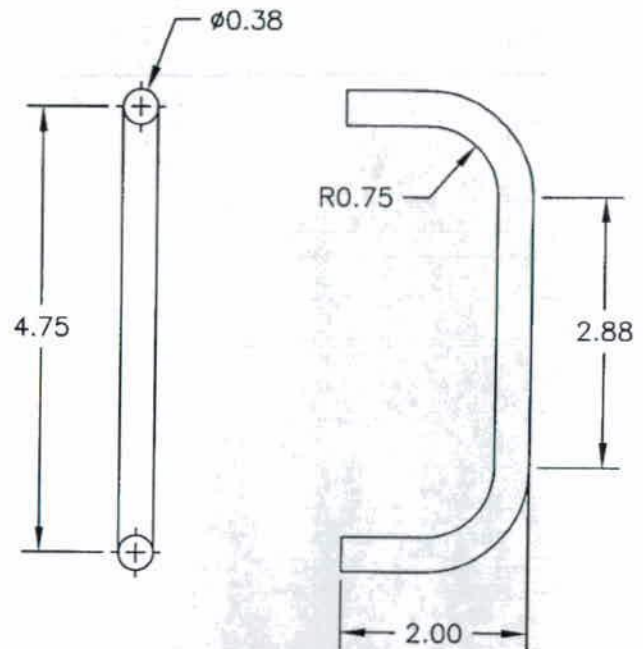
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED
07.12.07**1 D3330-9 TOP PLATE****2 D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

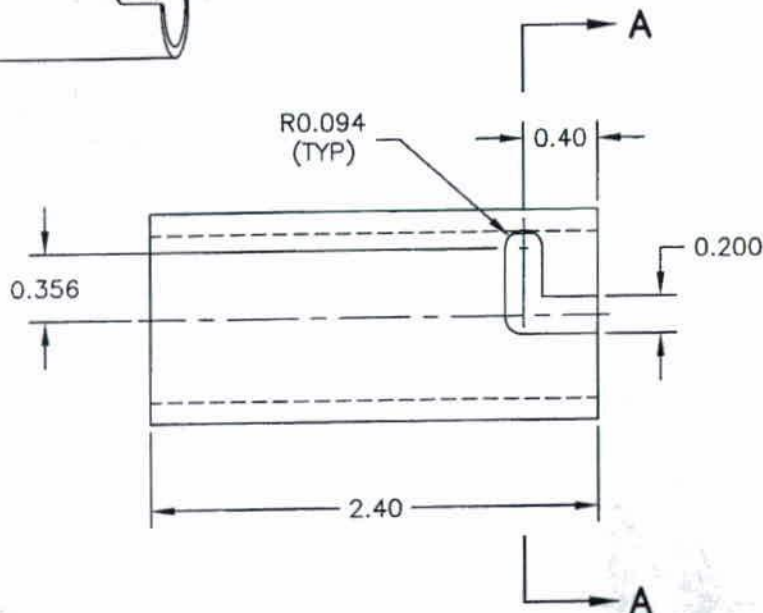
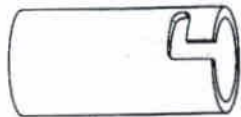
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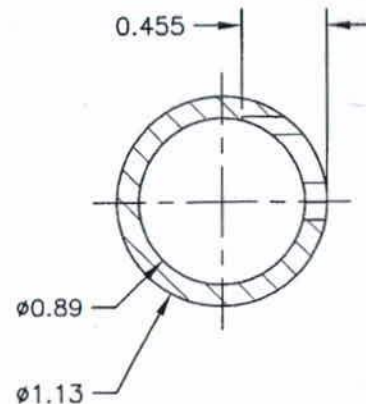
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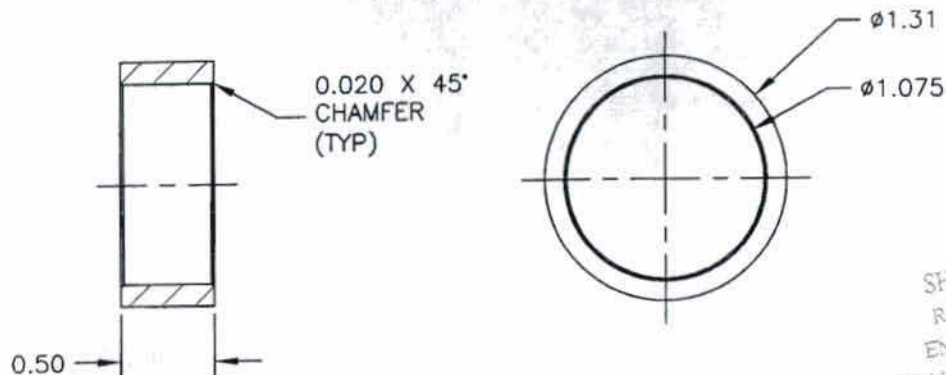


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SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

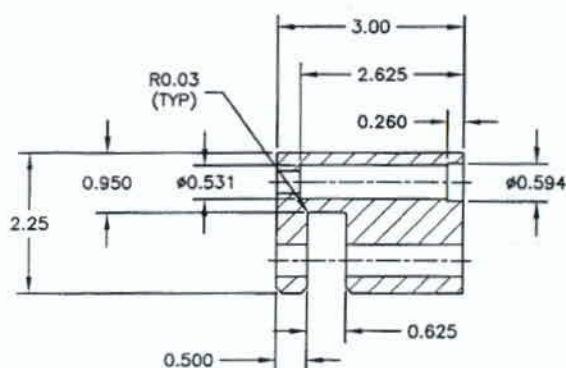
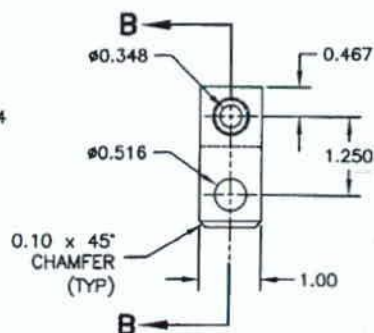
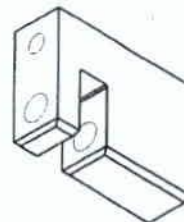
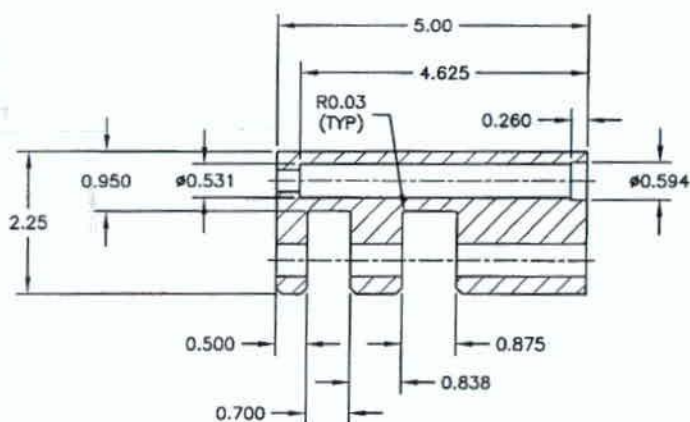
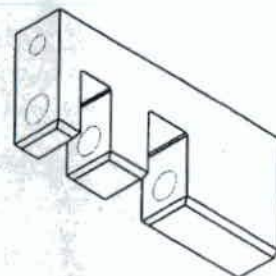
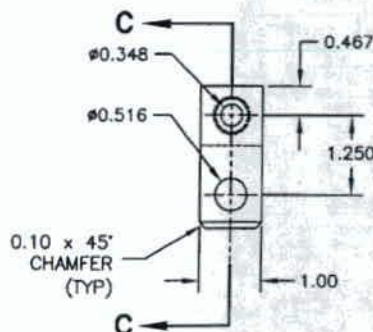
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

**SECTION B-B****RELEASED**
07.12.07 *[Signature]***D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
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